



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

RBW6405G00332-3G-7
Job Sheet 184951



Part No: RBW6405G00332-3G-7

Job Qty: 4 ea

Part Name: Slide Seat



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 10/19/18

Job Tracking No:

Due Date: 11/16/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG RBW6405G00332-3G Rev. 5 IPP Rev. A 18.09.24 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	4 Ea		11/16/18	0.00	0.00	Start Up Machining-3		AD 18-11-27
110	Mori Seiki	4 pcs		11/16/18	0.00	8.00	MORI NV5000-1		AD 18-11-27
120	QC	4 pcs		11/16/18	0.00	0.00	QC2 Machining-4		AD 18-11-27
122	Mill Conv	4 pcs		11/16/18	0.00	1.00	Mill Conv 2		AD 18-11-27
124	QC	4 pcs		11/16/18	0.00	0.00	QC2 Machining-4		AD 18-11-27
130	QC	4 pcs		11/16/18	0.00	0.00	QC8 Machining-4		AD 18-11-27
150	Outsource	4 pcs		11/16/18			GRO002-VC	8	AD 18-11-27
160	Packaging	4 pcs		11/16/18	0.00	0.00	Packaging2		AD 18-11-27
170	QC	4 pcs		11/16/18	0.00	0.00	QC6		AD 18-11-27
180	Packaging	4 pcs		11/16/18	0.00	0.00	Packaging3-1		AD 18-11-27
190	QC21-SA	4 Ea		11/16/18	0.00	0.00	QC21		AD 18-11-27

Part Op 110 - ***Cut blanks to 1.815"*** 1-Machine as per folio FC387 FOLIO REV: AA DWG REV: 5

Descriptions: 2-Deburr

122 - Machine as per DWG

130 - Engrave T/N and/or P/N number using MARKTRONIC engraver as per DWG.

150 - Issue P/O to GROUPE ALTECH; PO 041987 -ANODIZE COLOR CLEAR, PER IAW MIL-A-8625F TYPE 2 CLASS 1, Water sealant -Material type; 6061 -Certificate of Conformity is required

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6B1.500X2.000	6061-T6 Bar 1.50 X 2.00	3.6400 ft (.91 ea)	90-Start up Operation	5008417

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M6061T6B1.500X2.000	4	6	0

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____

Part No. _____

NCR No. _____

St _____

Date : _____ Step #: _____

Description Work Order D _____

AGAINST DEPARTMENT/PROCESS

Water Jet ☐

na Coord. ☐

Engineering ☐

Quality ☐

Other ☐

B (QSI042) Approval

Completed By

Lead hand / Supervisor
Approval Verification

QC / QA Coordinator
Approval

DART
AEROSPACE
Container No: S132499
Part: RBW6405G00332-3G-7
Job No: 184951
Serial No/ Batch: S132499
Inspector: 5
Exp Date: _____
Instructions: _____
Date: 11/20/18
Dart Aerospace Ltd.
1270 Aberdeen Street
Hewlettbury, ON K6A 1K7
TEL: 1 519 832-5200
Email: sales@dartaero.com
www.dartaerospace.com

Root Cause

Environment	☐	No Re-verification	☐
Design	☐	Operator	☐
Doc/Data	☐	Offset/Setup	☐
Equip/Tooling	☐	Supplier	☐
Handling/Pre	☐	Training	☐
Material	☐	Use for Testing	☐
Internal Transport	☐	Poor Information	☐
Tribal Knowledge	☐	Rushing	☐
LOA	☐	Product Improvement	☐
Substation	☐	Process Improvement	☐
Past Expiry Date	☐	Manufacturing Process	☐
Misidentified	☐	Past Due	☐

Pressure/Forced	☐
Bending	☐
Centre Not Concentric	☐
Cracks	☐
Crimp/Kink/Ripple/Wave	☐
Cuffs	☐
Crushing	☐
Heat Treat	☐
Wave/Twist in Tube	☐
Marks/Chatter	☐

Temperature/Cure	☐
Set-up	☐
BOM/Route	☐
Broken/Damage/Defect	☐
Inspection Incomplete/Unqualified	☐
Contamination	☐
Countersink	☐
Cut Too Short	☐
Instructions Incomplete/Unclear	☐
Drill Holes	☐

FAULT

Folio/Program	☐
Grain	☐
Weld	☐
Wrong Stock Pulled	☐
Out of Sequence	☐
Off-set	☐
Mislabeled	☐
Fit/Function	☐
Misaligned/off center	☐

Positioned Wrong	☐
Outside Dimensions	☐
Over/Under tolerance	☐
Part Incorrect	☐
Part Lost/Missing	☐
Part Moved	☐
Drawing	☐
Finish	☐
Misread	☐
Turning Sequence	☐

OTHER : _____

DART AEROSPACE LTD		Work Order:	184951
Description: slide seat		Part Number:	RBW6405 600332 -26-2
Inspection Dwg:	Rev: 5	Page 1 of 1	

INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
.490	H-.005	.488	✓		ML 06	
.631	H-.005	.630	✓		ML 06	
1.615	H-.005	1.615	✓		ML 06	
.980	H-.002	.9800	✓		ML 07	
.495	H-.005	.495	✓		ML 06	
1.057	H-.005	1.057	✓		ML 05	
Ø.094/1.097	min/max	Ø.094	✓		"	
.524	H-.005	.529	✓		"	
45°	H-.5°	44.8°	✓		block	
.626	H-.005	.629	✓		CNC 20	Fred
.159	H-.005	.159	✓		ML 06	
1.676	H-.005	1.675	✓		CNC 20	Fred
1.069	H-.005	1.067	✓		CNC 20	Fred
.631	H-.005	.629	✓		ML 06	
Ø.942	H-.005	.943	✓		ML 06	
Ø.19	H-.010	.191	✓		ML 06	
Ø.234	-tol H-.004	.233	✓		pin	
Ø.3738/3747		.3742	✓		pin	
Ø.750	H-.010	.753	✓		ML 06	
1.811	H-.005	1.813	✓		ML 06	
1.262	H-.005	1.262	✓		ML 06	
5-16/24 heli	70/110 70	70	✓		70/110 50	

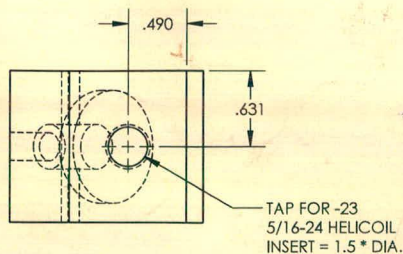
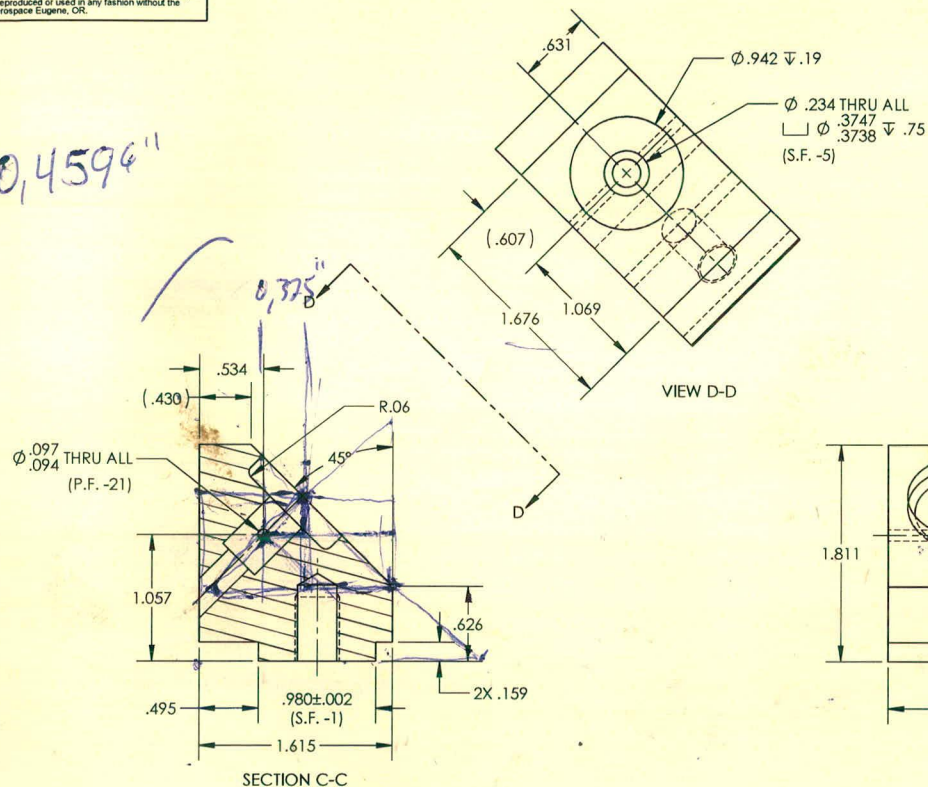
Measured by: P.J. Fred 18-11-20	Checked by: B.	QC Inspector:
Date: 18-11-27/18/11/29	Date: 18-12-02	Date:

Engineering Approval: (If necessary)	Date:
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Rev	Date	Change	Revised by	Approved
A	14.07.31	New Issue	KJ	

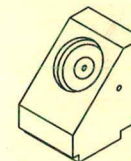
This drawing, specifications, and concepts contained here in are the sole property of Dart Aerospace, and may not be reproduced or used in any fashion without the prior written permission of Dart Aerospace Eugene, OR.

0.4596"



7
SLIDE SEAT

REVISIONS						
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVE	
1		-7 ADDED MISSING DIM FOR HOLE & CHD DIMS FOR HOLE LOCATION, DELETED .754 DIM, ADDED ENGRAVE NOTE, CHD FINISH SPEC.	5/4/2011	RJC		
2		-7 ADDED MISSING R.062 DIM, ADDED 1.584 AND .370 DIMS.	9/24/2012	JAG		
3		-7 ADDED LIMITS TO .374 DIM, ADDED LOCATION DIM FOR .098 HOLE (1.057).	2/5/2013	BIM	GE	
4	15-0298	-7 CHD ENGRAVE NOTE WAS ENGRAVE T/N IS ENGRAVE P/N, CHD DIM WAS .094 IS .097 - .094.	9/14/2015	RJC	JAG	
5	16-0233	-7 CHD DIMS WAS .234 THRU ALL L J .374 +.0007-.0000 .75 S.F. -5 IS .234 THRU ALL L J .3738-.3747 .75 (S.F. -5), WAS .094-.097 THRU IS .094-.097 THRU ALL (P.F. -21), WAS .328 .50 FOR -23 HELICOIL IS TAP FOR -23 5/16-24 HELICOIL INSERT = 1.5" DIA. WAS .980 S.F. -1 IS .9802 (S.F. -1), WAS .	11/28/2016	DPD	SM	



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 184951 MWS
187019

DART AEROSPACE	
TITLE T/R PITCH CONTROL LINK ADJUSTING TOOL	
DWG NO. RBW6405G00332-3G-7	REV 5
MATL 6061	UNLESS OTHERWISE SPECIFIED
FEAT .XXX ± .005 FRACTIONS ± 1/8	
DEAT .XX ± .01 ANGLES ± .5°	
FINISH CLEAR ANODIZE	SURFACES ± 125
SPEC MIL-A-8625, TYPE II, CLASS I	1. BREAK ALL SHARP EDGES
DRAWN BY: PERRITT	.015 ± .45° OR .015K
CHECKED: CLOUGH	2. DIMENSIONAL LIMITS APPLY
CPPS APPR: ANDERSON	AFTER PLATING
QA APPR: LINDSAY	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
APPROVED: MACKOVJAK	USED ON MODEL
SCALE 1:1	AGUSTA
DATE 1/13/2008	SHEET 5 OF 7



Dart Aerospace Ltd.
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Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **PO041987**

Supplier: GRO002-VC
Group Altech
2455 Halpern
St Laurent
QC
H4S 1N9 Canada
Phone: 514-335-3666
Fax: 514-335-3868

PO No: PO041987
PO Date: 12/7/18
Due Date: 12/18/18
Purchase Order
Revision:
Revision Date:
Ship-To Contact: Tsimiklis, ChrisoulaPhone:

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Via: Ground
Pynt Terms: Net 60
Freight Terms:
Special Comments:

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	185127	RBE117-12010W66-1	Ring 1 -Issue P/O to GROUPE ALTECH; PO -ANODIZE COLOR CLEAR, PER IAW MIL-A-8625F TYPE 2 CLASS 1, Water sealant -Material type; 6061T6 -Certificate of Conformity is required	Firmed	-	12/18/18	4 pcs	0 pcs	4 pcs	\$6.00/pcs	\$24.00
2	185119	RBE117-80168 W2-1	Tool 1 -Issue P/O to GROUPE ALTECH; PO -ANODIZE COLOR CLEAR, PER IAW MIL-A-8625F TYPE 2 CLASS 1, Water sealant -Material type; 6061T6 -Certificate of Conformity is required	Firmed	-	12/18/18	4 pcs	0 pcs	4 pcs	\$6.00/pcs	\$24.00



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PURCHASE ORDER **PO041987**

Items											
Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
3	184951	RBW6405G00332-3G-7	Slide Seat -Issue P/O to GROUPE ALTECH; PO -ANODIZE COLOR CLEAR, PER IAW MIL-A-8625F TYPE 2 CLASS 1, Water sealant -Material type; 6061 -Certificate of Conformity is required	Firmed	-	12/18/18	4 pcs	0 pcs	4 pcs	\$6.00/pcs	\$24.00
							4 X	DEC 17 2018			
											DAS 38 9-89
4	184948	RBW6405G00332-3G-11	Pointer -Issue P/O to GROUPE ALTECH; PO -ANODIZE COLOR CLEAR, PER IAW MIL-A-8625F TYPE 2 CLASS 1, Water sealant -Material type; 6061 -Certificate of Conformity is required	Firmed	-	12/18/18	4 pcs	0 pcs	4 pcs	\$6.00/pcs	\$24.00
							4 X	DEC 17 2018			
5	185128	RBE117-12010W66-3	Ring 2 -Issue P/O to GROUPE ALTECH; PO -ANODIZE COLOR CLEAR, PER IAW MIL-A-8625F TYPE 2 CLASS 1, Water sealant -Material type; 6061T6 -Certificate of Conformity is required	Firmed	-	12/18/18	4 pcs	0 pcs	4 pcs	\$6.00/pcs	\$24.00
							4 X	DEC 17 2018			
Grand Total:										\$120.00	



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PURCHASE ORDER PO041987

Order Notes

Procurement Quality Clauses

A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

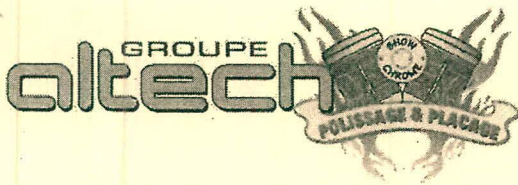
A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 12/12/18 12:33 PM dart.tsimiklis.chrisoula



Certificat de Conformité / Certificate of Compliance

(015176-1)

2455, Rue Halpern | Saint-Laurent | Québec | H4S 1N9
 Tel: 514-335-3666 Fax: 514-335-3868
 www.groupaltech.com

Bon de Livraison / Packing Slip

015176 - 1

Livré à / Ship to

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 Tel.: 613-632-5200 Fax.:

Client / Customer:

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 BUYER:

Date expédition Ship date		Créé Par Generated By	Transport / No de Compte Courier / Acc. No.		Bon de commande Client Customer Purchase Order No.				
11-Dec-2018		Aman			041987				
#Ligne Line#	No. de Série / # Pièce Part Number /Line Item Details Job # / Ref #	Description pièce(s)	CATG. U/M	Comm. /Ordered	Exp/ Shipped	Quantités / Quantities Qté NC/ NC Qty		Qté Scrap/	À venir/ Back Order
1	RBE117-12010W66-1 ✓ Rev.	RBE117-12010W66-1 01 -ANO-CLEAR [ANODIZE CLEAR] MIL-A-8625F TYPE 2 CLASS 1	ANODIZE CH	4	4 ✓	0	0	0	
2	RBE117-80168W2-1 ✓ Rev.	RBE117-80168W2-1 01 -ANO-CLEAR [ANODIZE CLEAR] MIL-A-8625F TYPE 2 CLASS 1	ANODIZE CH	4	4 ✓	0	0	0	
3	RBW6405G00332-3G-7 ✓ Rev.	RBW6405G00332-3G-7 01 -ANO-CLEAR [ANODIZE CLEAR] MIL-A-8625F TYPE 2 CLASS 1	ANODIZE CH	4	4 ✓	0	0	0	
4	RBW6405G00332-3G-11 ✓ Rev.	RBW6405G00332-3G-11 01 -ANO-CLEAR [ANODIZE CLEAR] MIL-A-8625F TYPE 2 CLASS 1	ANODIZE CH	4	4 ✓	0	0	0	
5	RBE117-12010W66-3 ✓ Rev.	RBE117-12010W66-3 01 -ANO-CLEAR [ANODIZE CLEAR] MIL-A-8625F TYPE 2 CLASS 1	ANODIZE CH	4	4 ✓	0	0	0	

Notes Additionnelles / Additional Notes

Epaisseur réelle
Actual Thickness

Inspecteur Qualité
Quality Inspector

Réçu par
Received By

Nous certifions que les pièces énumérées ci-dessus ont été traitées en conformité avec votre commande et vos spécifications et rencontrent les exigences.
 Notre responsabilité financière et légale ne sera pas supérieure au montant de la facture issue.

We hereby certify that the parts listed above have been process in accordance with your purchase order and specifications and are in conformance with your requirements.
 Our financial and legal responsibility will not be higher than the amount of invoice.

